

Work Order ID 116372

Monday, April 14, 2014 9:30:17 AM

116372

Page 1

Item ID: D350-588-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Aft Door Assembly

Stop ***NS2***

Start Date: 4/14/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/13/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: CZ Date: 14/04/14 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2445/D350-588	Rev D/D

JB

100	Document Control	0.00	JUN 19 2014	DAS 06 0-89
-----	------------------	------	-------------	-------------------

100

DC

Doc.Control -USB or Paperwork

Memo

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

MLS 1406-18

110

110

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: 23807
Description: D2445 Baggage Door
Supplier: Delastek
Ship to Delastek (1) D0588-041 label
Certification of Conformity and process sheet from Delastek is required.

0.00

0.00

CH751

CZ 14/04/15 ①

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Page 2

Small Fab

5-89
14/6/3

1x SO 14-6-2

1X EN 14.06.03

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Item ID: D350-588-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Aft Door Assembly

Stop *NS2*

Start Date: 4/14/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/13/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									
155	Pick Kit	0.00							
155									
Packaging	Memo	0.00							
Packaging									
160	QC4- 100% Inspect kits for completeness	0.00							
160									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89
14/6/4

DAS
33
9-89
14-06-03

1X
DAS
28
9-89

JUN 17 2014

JUN 19 2014

DAS
06
9-89

Work Order ID 116372

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Item ID: D350-588-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Door Assembly

Start Date: 4/14/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/13/2014 Req'd Qty: 1.00

1

Customer:

Reference:

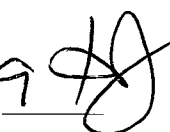
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>F-6 021</u>	0.00							
170									
Packaging	Memo	0.00		DAS 06 8-89	JUN 17 2014				
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

14/6/19 
ME
14-6-18

Picklist Print

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Work Order ID: 116372

116372

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 6/13/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP P 04.02.04ReformatKJ/DS
per DSI9414 DD verified by:EC
10.03.29 verified by:EC

IPP Rev:Q as
IPP Rev:R add pick kit DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C1032R7 Purchased No

AN526C1032R7

Screw

DAS
06
9-89

Location

Loc Qty

Loc Code

ST346

290

128831

8

M126175

32

M128403

250

155

Each

351.0000

8

**

DAS
28
9-89

JUN 17 2014

DAS
31
9-89

AN526C832R8 Purchased No

AN526C832R8

Screw

DAS
06
9-89

Location

Loc Qty

Loc Code

ST345

351

125388

14

m127817

87

m128403

250

140

Each

668.0000

8

**

DAS
28
9-89

DAS
31
9-89

AN526C832R9 Purchased No

AN526C832R9

Screw

Location

Loc Qty

Loc Code

ST345

668

M127363

4

M128403

64

M128429

600

**

DAS
33
9-89

14-06-03

128429

Picklist Print

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Page 2

Work Order ID: 116372

116372

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 6/13/2014

Start Qty: 1.00

Required Qty: 1.00

D2143

Manufactured No

140 Each

22.0000 1 1

DAS
33
9-89

D2143

Hinge Bracket

**

Location

Loc Qty

Loc Code

ST005

22

100918

12

108818

7

98391

3

100918

D2144

Manufactured No

140 Each

21.0000 1 1

DAS
33
9-89

D2144

Hinge Doubler

**

14-06-03

Location

Loc Qty

Loc Code

ST005

21

100467

21

100467

D2150

Manufactured No

155 Each

16.0000 2 2

DAS
28
9-89

D2150

Packer Doubler, Hinge

**

JUN 17 2014

DAS
06
9-89

Location

Loc Qty

Loc Code

ST005

16

112962

16

106861

D2151

Manufactured No

155 Each

34.0000 2 2

DAS
28
9-89

D2151

Packer Doubler

**

DAS
31
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST005

34

102125

2

106821

32

114304

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Shop Packet Print

Page 2

Picklist Print

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Work Order ID: 116372

116372

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 6/13/2014

Start Qty: 1.00

Required Qty: 1.00

D2153

Manufactured No

155

Each

60.0000

1

DAS

28

9-89

JUN 17 2014

D2153

Door Prop

**

Location

Loc Qty

Loc Code

FG

4

85865

4

ST260

56

100934

5

110755

18

114286

33

DAS

31

9-89

DAS
06
9-89

D2154

Manufactured No

155

Each

11.0000

1

DAS

28

9-89

D2154

Bracket, Stud

**

Location

Loc Qty

Loc Code

ST006

11

100839

11

110134

DAS

31

9-89

DAS
06
9-89

D2237

Manufactured No

155

Each

60.0000

2

DAS

28

9-89

D2237

Striker Plate

**

Location

Loc Qty

Loc Code

ST007

60

108708

20

112911

40

2x

DAS

31

9-89

DAS
06
9-89

D2445P

Purchased No

110

Each

0.0000

1

DAS

28

9-89

D2445P

Aft Door Assembly

**

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Shop Packet Print

Page 3

Picklist Print

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Work Order ID: 116372

116372

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 6/13/2014

Start Qty: 1.00

Required Qty: 1.00

D2461 Manufactured No

155 f

674.9700 7.25 8

D2461

Seal (\$Per Foot)

06
9-89 1V8711

Location

Loc Qty

Loc Code

ST402

674.97

102517

174.97

114238

500

**

DAS

28

9-89

JUN 17 2014

DAS

31

9-89

(D2461-0870) cut (1) at 87.00"

**** per kit****

D2463 Manufactured No

140 f

341.6337 7.25 8

D2463

1/2" Seal (\$Per Foot)

06
9-89 1V8711

Location

Loc Qty

Loc Code

ST402

341.633684

110718

341.633684

**

DAS

33

9-89

(D2463-0870) cut (1) at 87.00"

**** per kit****

D2585 Manufactured No

140 Each

65.0000 2 2

D2585

Latch Clamp

Location

Loc Qty

Loc Code

ST012

65

108520

1

110344

3

112571

19

112974

14

114114

28

**

DAS

33

9-89

14-06-03

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Picklist Print

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Work Order ID: 116372

116372

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 6/13/2014

Start Qty: 1.00

Required Qty: 1.00

D2586

Manufactured No

140

Each

47.0000

2

2

D2586

Door Latch

**

114985

DAS

33

9-89

Location

Loc Qty

Loc Code

FG

13

100607

2

83893

10

95760

1

ST198A

34

108573

24

113641

10

D2589

Manufactured No

155

Each

21.0000

1

1

D2589

Keys, Key Chain

DAS

06

9-89

**

DAS

28

9-89

JUN 17 2014

Location

Loc Qty

Loc Code

ST012

21

58194

21

D2621

Manufactured No

140

Each

48.0000

2

2

D2621

Latch Plate

**

DAS

33

9-89

14-06-03

Location

Loc Qty

Loc Code

FG

2

88616

2

ST013

46

108138

3

115195

43

115195

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Work Order ID: 116372

116372

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 6/13/2014

Start Qty: 1.00

Required Qty: 1.00

D2690-17

Manufactured No

155

Each

33.0000

1

1

D2690-17

Cable

DAS

JUN 17 2014

28

9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST016

33

100752

3

108397

5

110028

6

112206

6

114912

12

94470

1

IX

DAS
31
9-89

D2857-1

Manufactured No

140

Each

44.0000

1

1

D2857-1

Hinge Bracket

DAS

33

9-89

14-06-03

Location

Loc Qty

Loc Code

FG

5

82261

4

91914

1

ST019

39

106185

3

110247

12

113744

24

113744

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Work Order ID: 116372

116372

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 6/13/2014

Start Qty: 1.00

Required Qty: 1.00

D2857-2

Manufactured No

140

Each

52.0000

1

1

DAS
33
9-89

14-06-03

D2857-2

Hinge Bracket

**

Location

Loc Qty

Loc Code

FG

3

78904

3

ST019

25

100769

1

108401

24

ST024

24

114154

24

108401

D2858-1

Manufactured No

155

Each

46.0000

1

DAS
28
9-89

JUN 17 2014

D2858-1

Hinge Bracket

**

Location

Loc Qty

Loc Code

FG

2

77019

2

ST019

44

100756

8

110032

12

114144

24

IX

DAS
31
9-89

DAS
06
9-89

D2858-2

Manufactured No

155

Each

44.0000

1

DAS
28
9-89

D2858-2

Hinge Bracket

**

Location

Loc Qty

Loc Code

FG

2

77020

2

ST020

42

105555

18

113735

24

IX

DAS
31
9-89

DAS
06
9-89

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Work Order ID: 116372

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

116372

D350-588-041

Start Date: 4/14/2014

Required Date: 6/13/2014

Start Qty: 1.00

Required Qty: 1.00

FG-778150-550-ROL

Purchased

No

155

sf

2,378.000

1

*FG-778150-550-ROL *

7781 9oz Glass 50x125yd

**

DAS

28

9-89

JUN 17 2014

DAS

31

9-89

Location

Loc Qty

Loc Code

CA

2378

M127570

815

M127701

1563

1x

CUT ONE SQUARE FEET PER

MS20426AD3-4

Purchased

No

155

Each

7,961.000

12

MS20426AD3-4

RIVET

**

DAS

28

9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

MF4

365

125578

365

ST334

3192

m127432

3192

ST509

4404

125578

4404

12x

DAS
06
9-89

MS20470AD4-5

Purchased

No

155

Each

4,029.000

18

MS20470AD4-5

RIVET, UNIVERSAL HEAD

**

DAS

28

9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

GA

7

m126926

7

ST336

4022

m126926

716

m128401

1653

m128813

1653

18x

DAS
06
9-89

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Work Order ID: 116372

116372

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 6/13/2014

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

140

Each

6,190.000

8

8

DAS
33
9-89

MS21042I 08

Nut

14-06-03

Location

Loc Qty

Loc Code

ST314

3558

123900

58

m128401

1500

m128429

2000

ST508

2533

125445

1135

m127410

1398

ST509

99

m127304

99

128429

MS21042L08

Purchased

No

155

Each

6,190.000

10

10

DAS
28
9-89

MS21042I-08

Nut

JUN 17 2014

Location

Loc Qty

Loc Code

ST314

3558

123900

58

m128401

1500

m128429

2000

ST508

2533

125445

1135

m127410

1398

ST509

99

m127304

99

10X

DAS
06
9-89

DAS
31
9-89

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Work Order ID: 116372

116372

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 6/13/2014

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

140

Each

8,800.000

2

2

MS21042L3

Nut

DAS
33
9-89

14-06-03

Location

Loc Qty

Loc Code

ST314

1845

M127410

804

M127831

41

M128401

1000

ST506

955

123900

955

ST509

6000

M128754

6000

MS21042L3

Purchased

No

155

Each

8,800.000

4

4

MS21042L3

Nut

DAS
28
9-89

JUN 17 2014

Location

Loc Qty

Loc Code

ST314

1845

M127410

804

M127831

41

M128401

1000

ST506

955

123900

955

ST509

6000

M128754

6000

DAS
06
9-89

DAS
31
9-89

4X

Picklist Print

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Work Order ID: 116372

116372

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 6/13/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

155

Each

5,383.000

2

2

NAS1149D0363.J

Washer

DAS
06
9-89

Location

Loc Qty

Loc Code

GA

23

124392

23

ST510a

5360

m126319

130

m127813

230

m128429

5000

140

Each

2,506.000

8

8

NAS1149DN832J

Purchased

No

NAS1149DN832.J

Washer

Location

Loc Qty

Loc Code

MF4

912

M127255

912

ST293

1432

M127813

432

M128429

1000

st510

145

124555

145

ST510a

17

M126319

17

DAS
28
9-89

JUN 17 2014

DAS
31
9-89

**

128948

DAS
33
9-89

14-06-03

Picklist Print

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Work Order ID: 116372

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 6/13/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN832J

Purchased

No

155

Each

2,506.000

16

16

DAS

~~*NAS1149DN832J*~~

Washer

**

33

9-89

14-06-03

Location

Loc Qty

Loc Code

MF4

912

M127255

912

ST293

1432

M127813

432

M128429

1000

st510

145

124555

145

ST510a

17

M126319

17

128948

DAS
28
9-89

JUN 17 2014

DAS
06
9-89

DAS
31
9-89

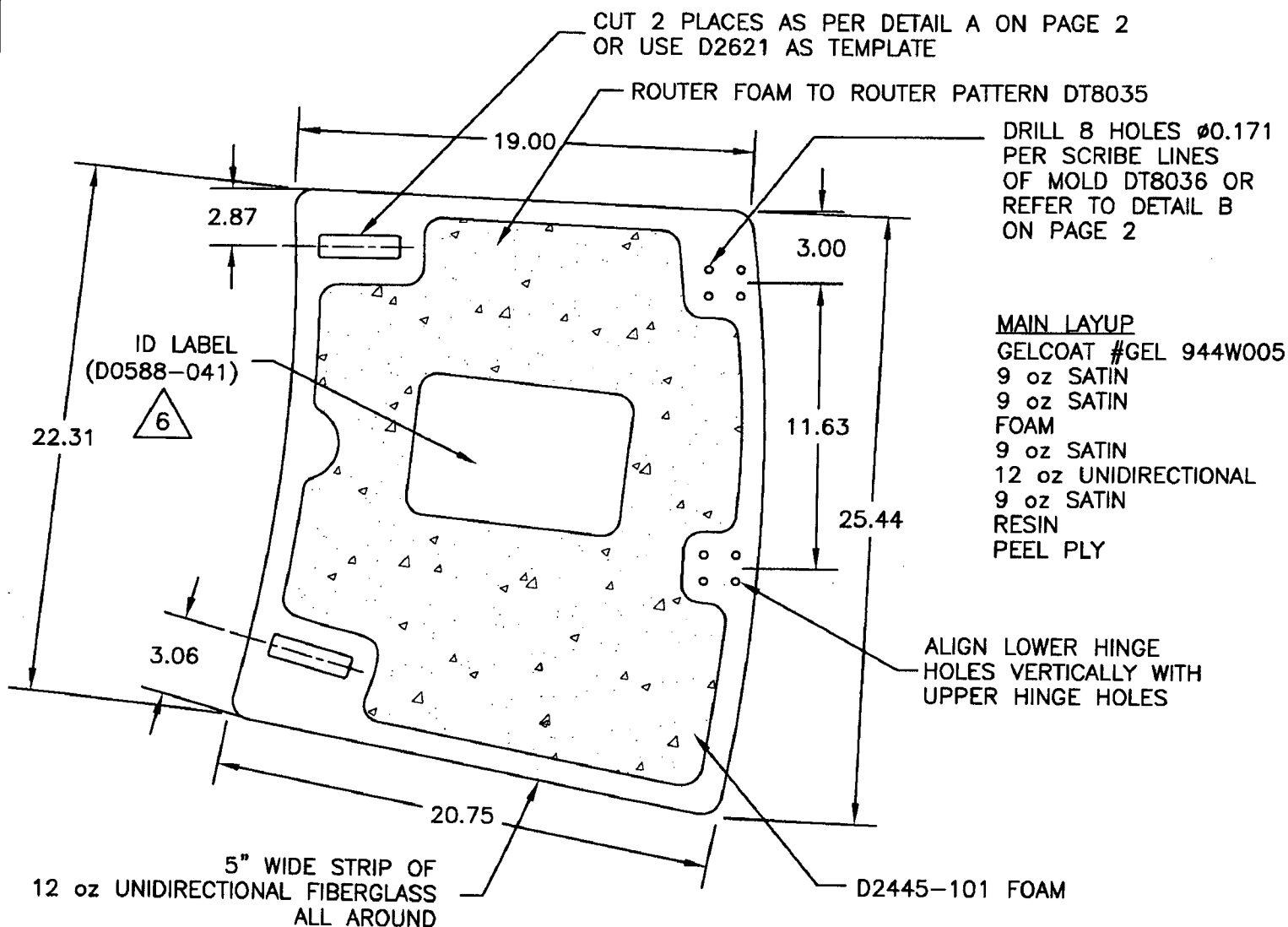
D35080-041 B119725

DAS
31
9-89

DAS
06
9-89

DART

DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 1 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:7
A	97.07.15	NEW ISSUE	
B	02.01.24	ADD D2621; D2445-101	
C	04.02.09	REMOVE D2621; UPDATE NOTES	
D	06.06.09	ADD DIMENSIONS TO PERIMETER	

RELEASED06.11.13 *[Signature]***NOTES:**

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DIVINCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

0214104114
*W10:116372***Copyright © 1997 by DART AEROSPACE LTD**

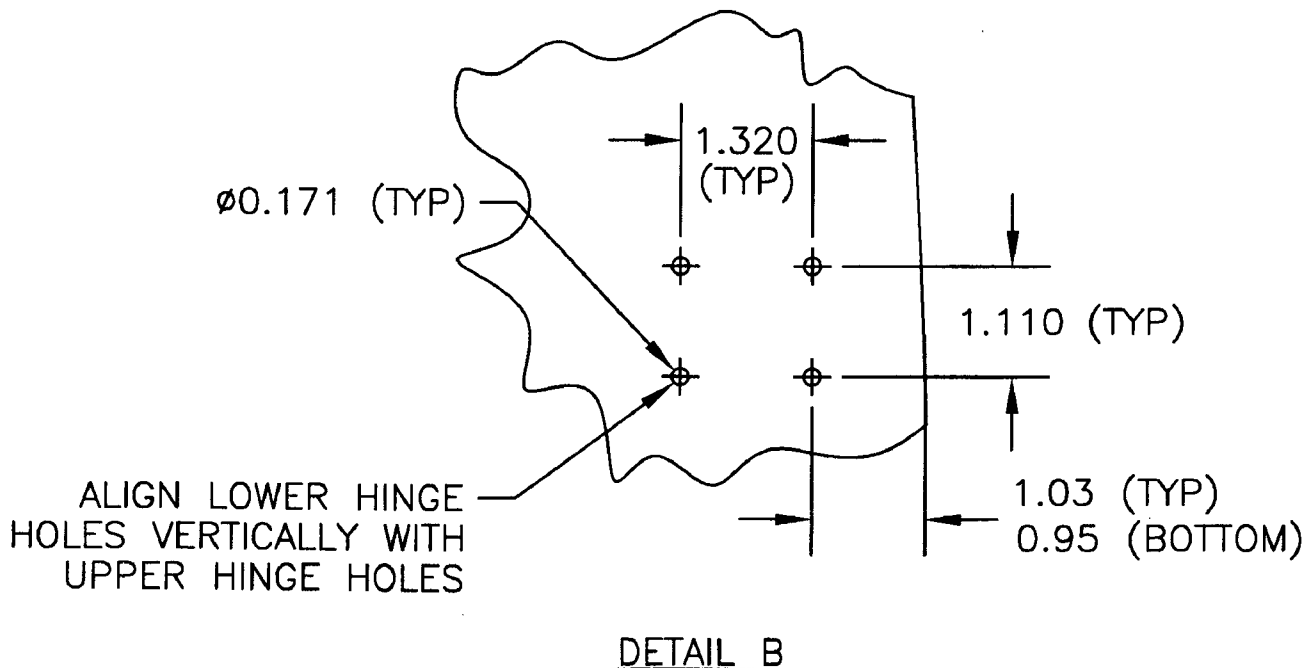
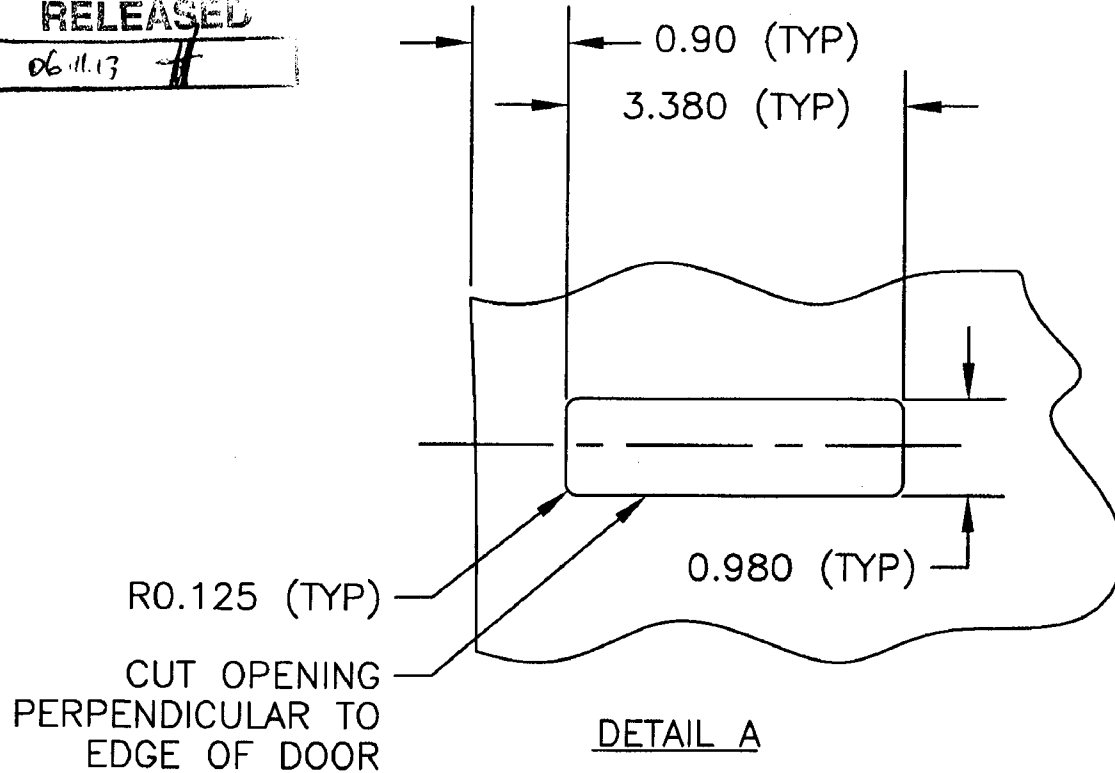
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DART

DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 2 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:2

RELEASED

06.11.13 *[Signature]*



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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--

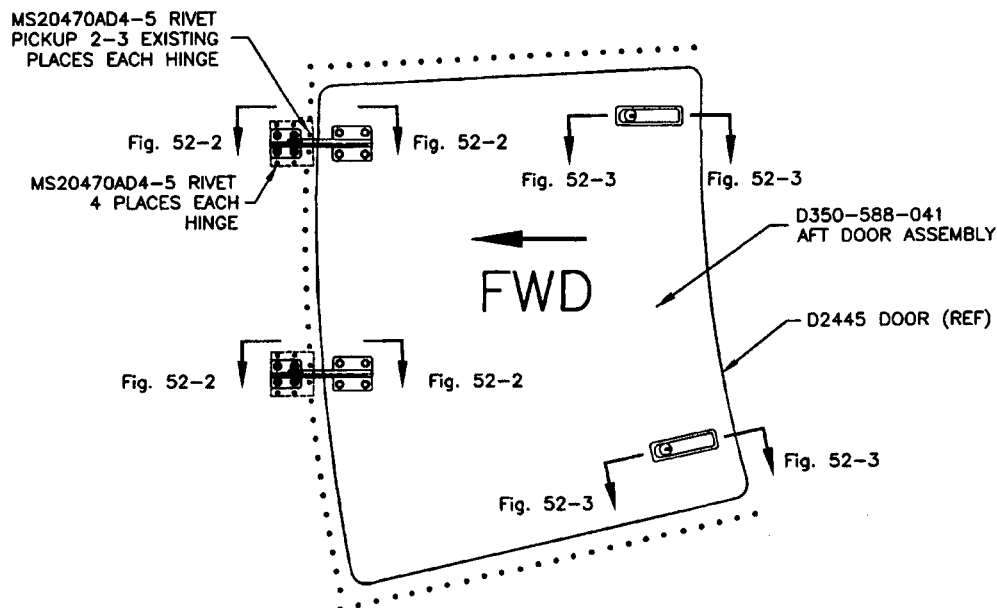


Figure 52-1: Baggage Door Outside View

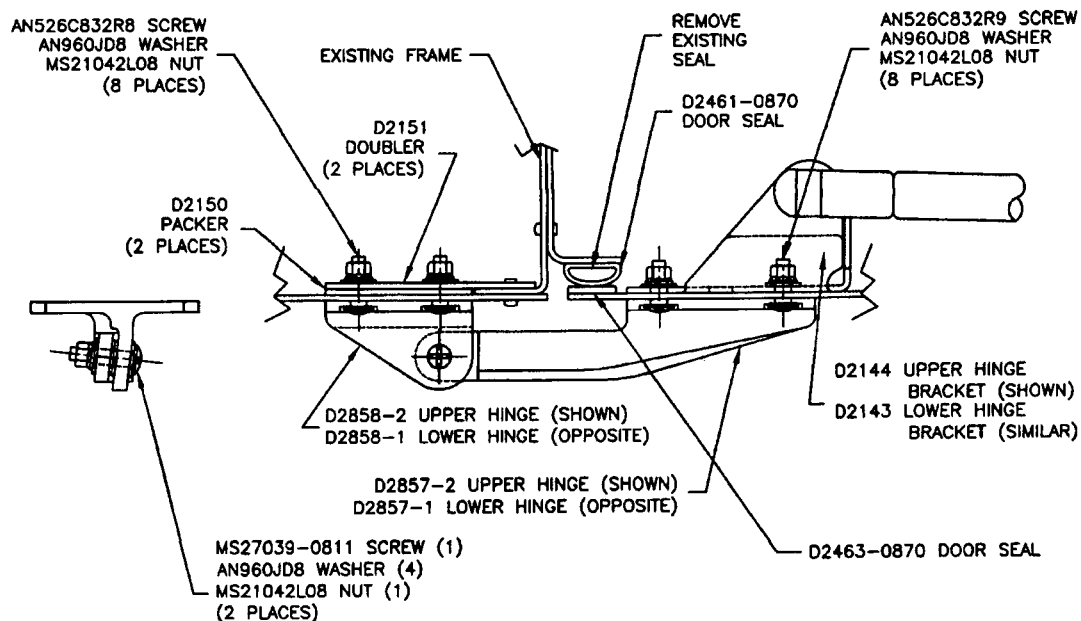


Figure 52-2: Hinge Detail

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52-00-00

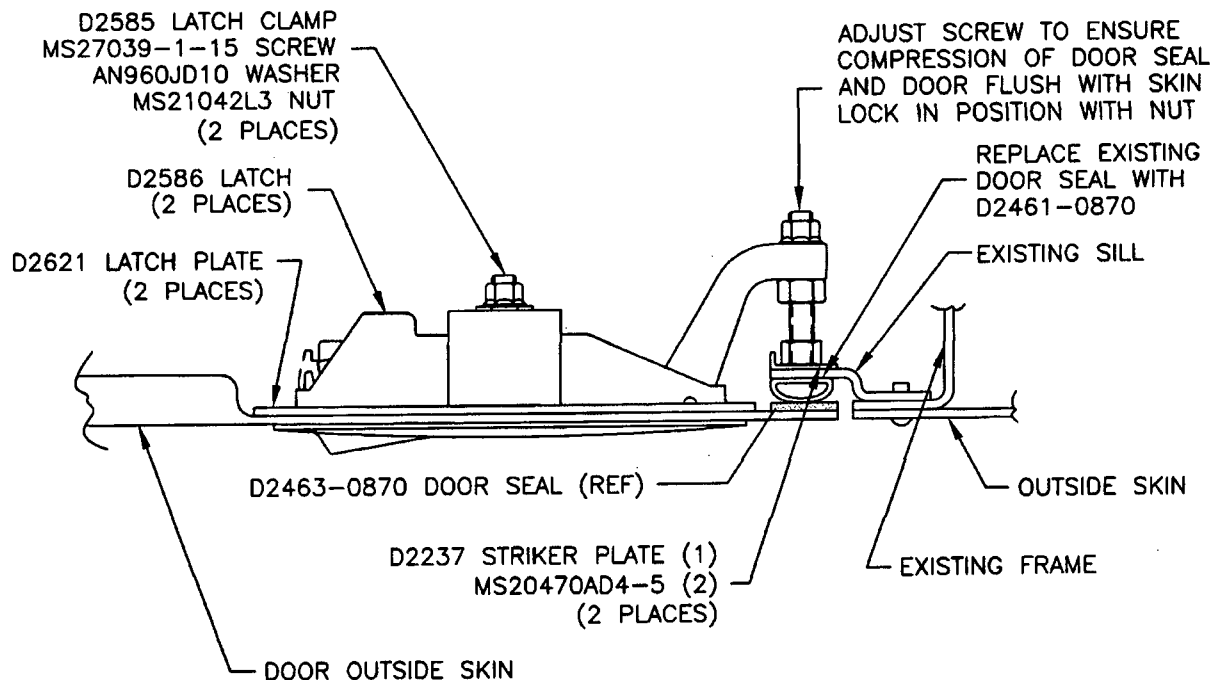


Figure 52-3: Latch Section

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52-00-00

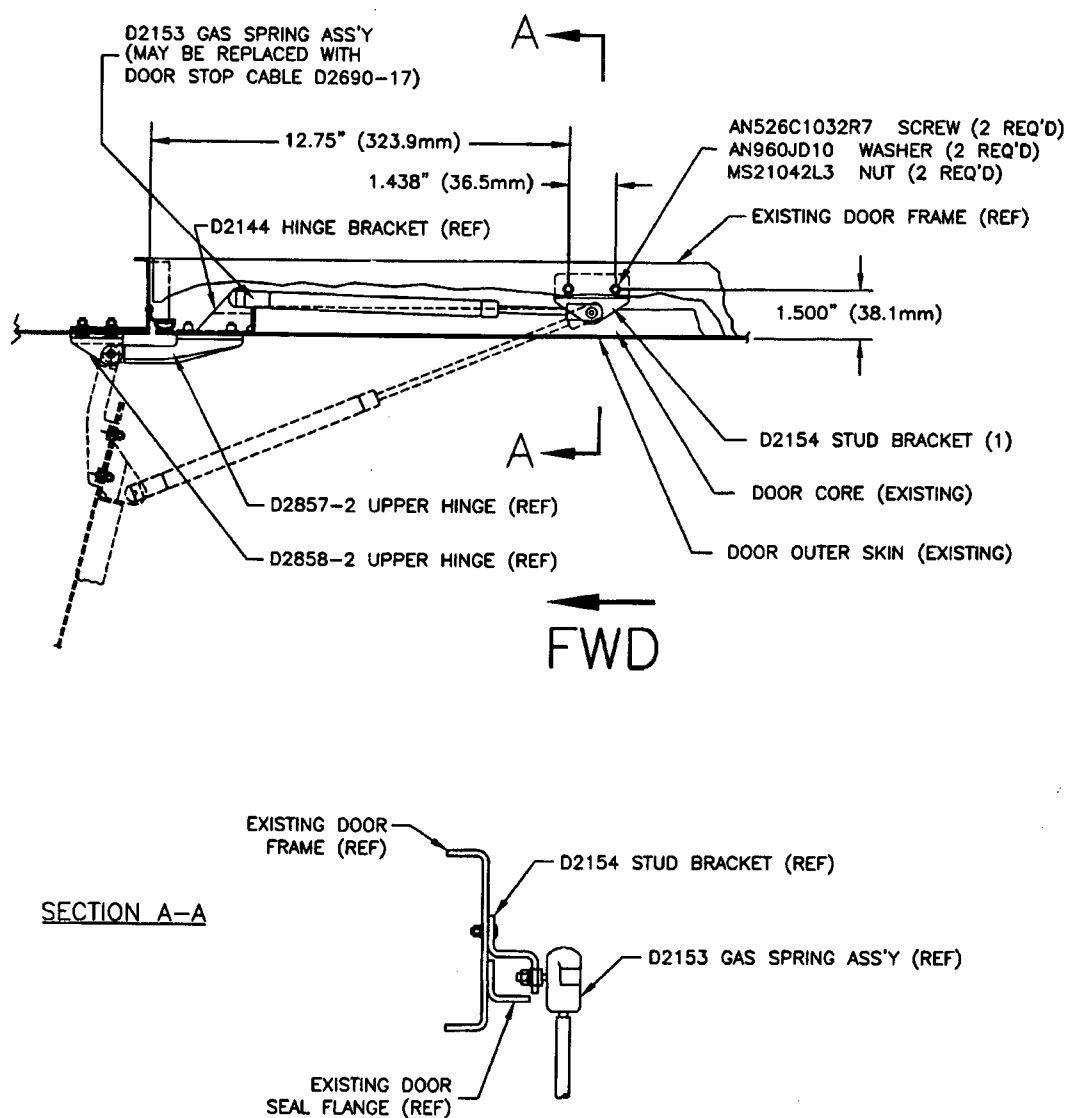


Figure 52-4: Gas Spring Installation

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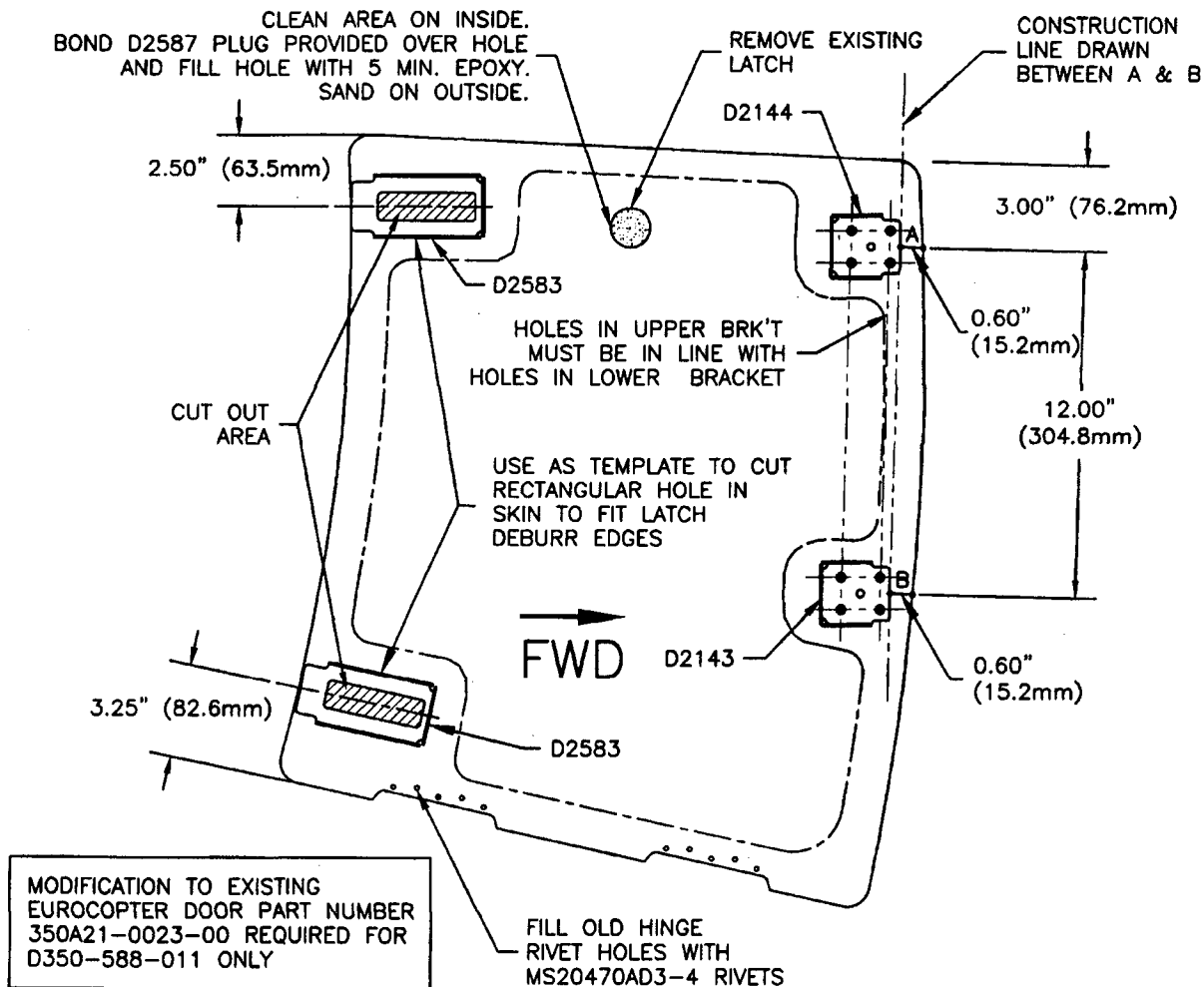


Figure 52-5: Baggage Door Inside View

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52-00-00

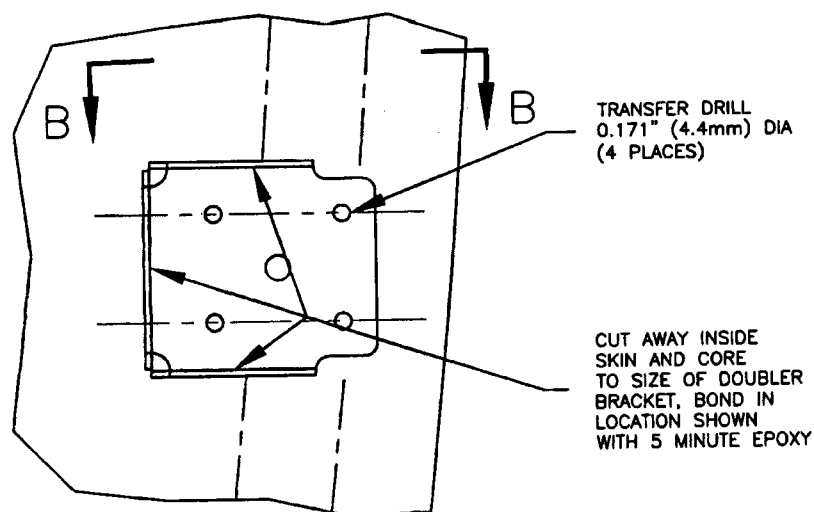
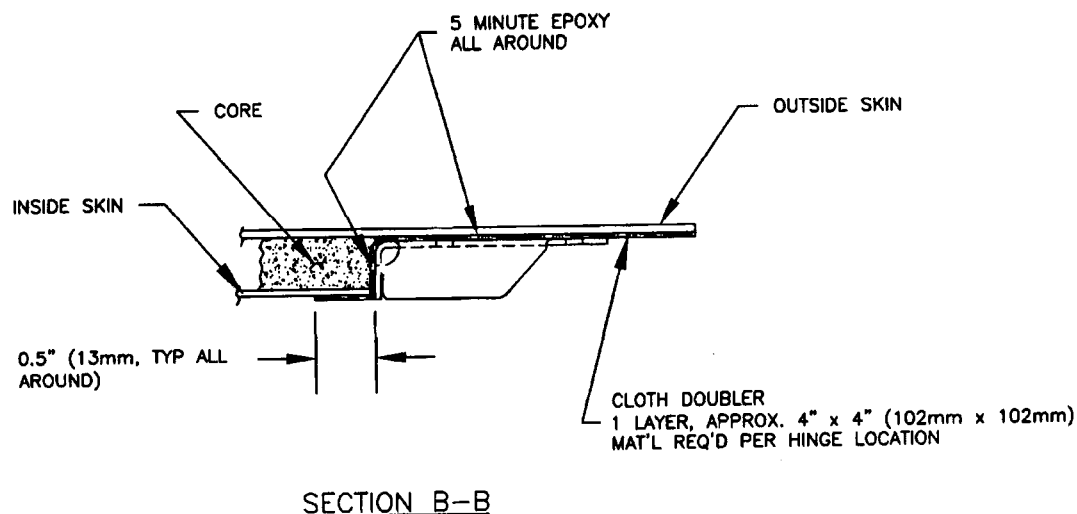


Figure 52-6: Typical Doubler Bracket Installation

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52-00-00



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23807

Purchase Order Date 4/15/2014

PO Print Date 4/15/2014

Page Number 2 of 3

Order From :

DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

VU-DEL003

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

819 533 5788

Ship To Contact

Ship To Phone

Ship Via:

FedEx PI collect

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

USD

FCA - (Free Carrier)

Line Total:

\$59

4 D2445P

Aft Door Assembly

5/30/2014

Yes

5/30/2014

1.00
Each

\$592.76

\$59

AS PER DWG D2445 REV. D
B116370

1-14/0726

Line Total:

\$59

5 D2445P

Aft Door Assembly

6/10/2014

Yes

6/10/2014

1.00
Each

\$592.76

\$59

AS PER DWG D2445 REV. D
B116371

Line Total:

\$59

6 D2445P

Aft Door Assembly

6/10/2014

Yes

6/10/2014

1.00
Each

\$592.76

\$59

AS PER DWG D2445 REV. D
B116372

SP14-6-2

Note:

4/15/2014



DELASTEK Inc.
2699 5e Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice No.	57445
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
30-05-2014	15-04-2014	24538	Chantal Lavoie	PO23807	Net 30 days USA
Ship Via		F.O.B.		Salesperson	GST/PST
FEDEX P1 Collect		Point de départ		Jocelyne Laurin, 221	
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0013	Line #5 Aft Baggage Door (D2445) B116371 U of M: Chaque Drawing N° : D2445 Rév.: D	
				DOCUMENT INCLUS	
				Serial #	Lot #
				B116371	61089
1	0	1	DKC134-0013	Line #6 Aft Baggage Door (D2445) B116372 U of M: Chaque Drawing N° : D2445 Rév.: D	
				Serial #	Lot #
				B116372	61087

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Quality department

AQ-357



☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Mercredi, 2014-04-16 08:13:59
Utilisateur: marc dubé

Feuille de Procédé

1/30 Avril

Client : DART US DART AEROSPACE
Numéro Job : 61087
Numéro : 3959
Numéro B.A. :
Cette fois : 2014-04-16 No. :
Prsht Rev. : NC
Prem. fois : - - Type :
Job précédente : 55240Nom Dessin : N° D2445, AFT BAGGAGE DOOR
Numéro Article : DKC134-0013
Numéro Dessin : D2445
Projet Numéro : DK-362
Révision dessin : D
Matériel : Composite
Date Dûe : 2014-05-30 Qté: 1 Ud UNITEÉcrit par :
Vérifié & Approuvé par :
Commentaires : N° de pièce Client: N/A

E.O.: N/A

Feuille de Procédé Rév.: 05 ajout de l'IF134-0007 sur
plusieurs séquences, numéro du moule passe de
DT-8036 pour DKO-0235, numéro du moule passe de
DT-8619 pour DKO-0063, ajouter IF134-0006 pour le
taillage

Formulaire d'inspection: N/A

B116372

COPIE

Produit additionnel

Numéro Job:

# Séq.: Machine ou Description :
1.0 AAC1616 N° 83634, Frekote Loctite WoloComment Qty.: 0.200 UNITE(s)/Unit Total: 0.200 UNITE(s)
N° 83634, Frekote Loctite Wolo # de Lot: 1-42289-1

2.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation du moule N° DKO-0235 selon IG 0009.

Date: 25/04/14 Sceau:



3.0 AMB0350 Gel Coat Blanc N° Gel 944W005

Comment Qty.: 0.200 KILOGRAMME(s)/Unit Total: 0.200 KILOGRAMME(s)
Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-45003-2












4.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.0320 GALLON(s)/Unit Total: 0.0320 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

872378

Date: Mercredi, 2014-04-16 08:13:59
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: N° D2445, AFT BAGGAGE DOOR	
Numéro Job: 61087		Numéro DKC134-0013	
Numéro Job: 			
# Séq.:	Machine ou Opération:	Description :	
5.0	PREP-GENERAL	Préparation du matériel	
 			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.			
Date: <u>25/04/14</u> Sceau:  			
6.0	GEL COAT	Application du Gel Coat	
 			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire l'application du Gelcoat selon IF134-0007			
Date: <u>25/04/14</u> Sceau:  			
7.0	AAC1885	Tissu à délaminer Release ply B	
Comment Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)			
Tissu à délaminer Release ply B # de Lot: <u>N/A</u>			
8.0	AAC1887	Wrightlon 5200 Bleu P3	
Comment Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)			
Wrightlon 5200 Bleu P3 # de Lot: <u>N/A</u>			
9.0	AC0885	Feutre de drainage N° Airweave N 10	
Comment Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)			
10.0	AC0943	Stretchlon 200 poche à vide Vert	
Comment Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)			
11.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish	
Comment Qty.: 2.00 VERGE(s)/Unit Total : 2.00 VERGE(s)			
9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: <u>1-44353-3</u>			
12.0	AMB0511	N° TG-13-U, Fiberglass 13 oz	
Comment Qty.: 0.33 VERGE(s)/Unit Total : 0.33 VERGE(s)			
N° TG-13-U, Fiberglass 13 oz N° de Lot: <u>1-36302-1</u>			
13.0	AC0886	Ruban à gommer jaune #: T/AT-200Y	
Comment Qty.: 1.2500 ROULEAU(s)/Unit Total : 1.2500 ROULEAU(s)			
14.0	PREP-GENERAL	Préparation du matériel	
 			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Découper les tissus selon IF134-0007.			
Information de référence pour les tissus::			

Date: Mercredi, 2014-04-16 08:13:59

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 61087

Numéro DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description :

4 plis de tissus de 9.7 oz.
1 pli de 13 oz. pour tout le contour de la pièce par 5" de large.
3 fois le sac à vide Strechlon 200.
3 fois le film perforé P-3
3 fois le feutre de drainage
2 fois le tissu à délaminer (non nécessaire lors du bagging du core).

Date: 20/4/14 Sceau:



15.0

AMB0286

Catalyst N° DDM-9

Comment Qty.: 0.0130 GALLON(s)/Unit Total: 0.0130 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

16.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.360 KILOGRAMME(s)/Unit Total: 0.360 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-45003-1

17.0

PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requise, mix ratio 1.5% de catalyst N°
DDM-9 par quantité de résine N° 411-350

Date: 25/04/14 Sceau:



18.0

LAMINAGE

Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Laminer la pièce selon IF134-0007.

Date: 25/04/14 Sceau:



19.0

BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure Curing début: 3:00 Heure Curing Fin: 8:00

Date: 25/04/14 Sceau:



Date: Mercredi, 2014-04-16 08:13:59
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 61087

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

20.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.0042 GALLON(s)/Unit Total : 0.0042 GALLON(s)

Catalyst N° DDM-9

N° de Lot: ~~1-45003-1~~ RC 1-27829-1

21.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.120 KILOGRAMME(s)/Unit Total : 0.120 KILOGRAMME(s) RC

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: ~~1-27829-1~~ 1-45003-1

22.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requise, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core selon IG0105.

Date: / Sceau:



23.0 AAC1611 Polybond B46F

Comment Qty.: 0.045 KIT(s)/Unit Total : 0.045 KIT(s)

Polybond B46F

N° de Lot: ~~1-38189-1~~

24.0 DKC134-0029 Foam Core N° D2445-101 (Pour AFT Baggage Door)

Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

Foam Core N° D2445-101 (Pour AFT Baggage Door)

N° de Job: 61094

25.0 ASSEMBLAGE Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Coller le Foamcore selon IF134-0007.

Date: 28-04-14 Sceau:



26.0 BAGGING Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012

Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.

Heure début Curing: 9.00

Heure Fin Curing: 10.15

Date: 28-04-14 sceau:



Date: Mercredi, 2014-04-16 08:13:59
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 61087

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

27.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.1360 GALLON(s)/Unit Total: 0.1360 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-2 7329-1

28.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.360 KILOGRAMME(s)/Unit Total: 0.360 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-45608-1

29.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de catalyst
N° DDM-9 par quantité de résine N° 411-350.

Date: 29-04-14 Sceau:

30.0 LAMINAGE Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire le laminage des tissus de verre selon IF134-0007.

Date: 29-04-14 Sceau:

31.0 BAGGING Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la poche à vide selon IG 0012

Laisser sécher pendant 4 heures minimum.

Heure Curing Début: 8.45 Heure Curing Fin: 9.25

Date: 29-04-14 Sceau:

32.0 DÉMOULAGE Démoulage de la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs














Démouler la pièce en faisant bien attention aux coins & rebords.

Date: 30-04-14 Sceau:

Date: Mercredi, 2014-04-16 08:13:59













Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE	Nom Dessin: N° D2445, AFT BAGGAGE DOOR	
Numéro Job: 61087	Numéro DKC134-0013	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
33.0	TRIMAGE	Trimage
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Tailler la pièce selon IF134-0006. Date: 30-04/14 Sceau: 		
34.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler
Comment Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-5373-1		
35.0	FINITION	Finition Générale
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire les réparations de finition s'il y a lieu à l'aide du "Filler" P15-3. Date: 30-04/14 Sceau: 		
36.0	AAC1021	Dupont Primer N° 7704S
Comment Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s) Dupont Primer N° 7704S N° de Lot: 1-5456-3		
37.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase
Comment Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-44895-1		
38.0	PRIMER	Application primer
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la préparation et l'application du primer batisseur selon I.G. 0008 Date: 01/05/14 Sceau:  # de fiche de mélange: 6591		
39.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler
Comment Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-45373-1		
40.0	FINITION	Finition Générale
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire les réparations de finition s'il y a lieu à l'aide du "Filler" P15-3. Date: 05-05/14 Sceau: 		

Date: Mercredi, 2014-04-16 08:13:59
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	N° D2445, AFT BAGGAGE DOOR
Numéro Job:	61087	Numéro	DKC134-0013
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
41.0	AAC1605	Label N° D0588-041	
Comment	Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) Label N° D0588-041 N° de Lot: <u>1-95570-1</u> 		
42.0	AAC1609	Surface Veil	
Comment	Qty.: 0.07 VERGE(s)/Unit Total : 0.07 VERGE(s) Surface Veil N° de Lot: <u>1-44695-1</u>		
43.0	AAC1220	Résine Mia-Poxy 100	
Comment	Qty.: 0.007 GALLON(s)/Unit Total : 0.007 GALLON(s) Résine Mia-Poxy 100 N° de Lot: <u>1-70095-4</u>		
44.0	AAC1221	Durcisseur 95 Pour Résine Mia-Poxy	
Comment	Qty.: 0.007 QUART(s)/Unit Total : 0.007 QUART(s) Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: <u>1-34505-1</u>		
45.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Coller le label N° D0588-041 selon IG 0111. Date: <u>05-05-14</u> Sceau: 		
46.0	AAC1021	Dupont Primer N° 7704S	
Comment	Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>1-54556-3</u>		
47.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Comment	Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>1-44895-1</u>		
48.0	PRIMER	Application primer	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la préparation et l'application du primer final selon I.G. 0008 Date: <u>06-05-14</u> Sceau:  # de fiche de mélange: <u>6595</u> <i>manque étape de démasquage</i>		
49.0	INSPEC FINAL	Inspection finale	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire l'inspection selon le dessin N° D2445. Date: <u>06-05-14</u> Sceau:  <i>Défauts dans le môle</i> 		

Date: Mercredi, 2014-04-16 08:13:59
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 61087

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description :

50.0

EMBAL / ENTREPO

Emballage & Entreposage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'emballage des pièces selon IG 0057

Date: 8-5-14 Sceau: 4451